

Work Order ID 66831-2

Monday, February 28, 2011 11:40:40 AM



Page 1

Item ID: D3512-1

Accept



Setup Start



Revision ID:

Item Name: Wearplate

Stop



Start Date: 2/28/2011 Start Qty: 12.00

Required Date: 3/4/2011 Req'd Qty: 12.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

QC:

Date: 11-02-28 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3512

Rev C

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3512  
Deburr if necessary

Dwg Rev: C

Prog Rev: C 2-

AB 11-3-2

(D)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

AB 11-3-2

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sum 11/02

(H2)

# Work Order ID 66831

Monday, February 28, 2011 11:40:40 AM



Page 2

Item ID: D3512-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 2/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr if necessary Form as per dwg D3512 using DT8179

2/28/11 11:40:40 AM

(12)

140

QC - Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2/28/11 11:40:40 AM

(42)

150

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld hard surface using DT8874 as per Dwg D3512 & QSI 004 City  
Description Batch A/R 2059b Hardcoat Rod

2/28/11 11:40:40 AM

EL 11-6-8

(18)

# Work Order ID 66831

Monday, February 28, 2011 11:40:40 AM



Page 3

Item ID: D3512-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 2/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

Subtotal

170

QC15- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Subtotal

(+8)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME

FINISH TIME

OVEN TEMPERATURE

NI 115128

320°F

1:20

1750

8x Ø m-214/06/08

# Work Order ID 66831

Monday, February 28, 2011 11:40:40 AM



Page 4

Item ID: D3512-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 2/28/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/4/2011 Req'd Qty: 12.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC3- Inspect Part Finish

0 00



QC

Memo

0 00

Quality Control

8 0 all n106108

200

Identify as per dwg & Stock Location 500

0 00



Packaging

Memo

0 00

Packaging

11/6/8 SP-8x

219

QC21- Final Inspection - Work Order Release

0:00



QC

Memo

0 00

Quality Control

11/6/9 J

mf

11-06-08

# Picklist Print

Monday, February 28, 2011 11:40:46 AM

Page 1

Work Order ID: 66831



Parent Item: D3512-1

Parent Item Name: Wearplate

Start Date: 2/28/2011

Required Date: 3/4/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 06-06-20 JLM  
IPP Rev:B Now SS as per Rev B 06-12-15 JLM  
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	39 8400	0.261	3.296842			



304/316 Sheet 063



Bill-3-2

Location

Loc Qty

Loc Code

MAI

39 84

111323

0

116623

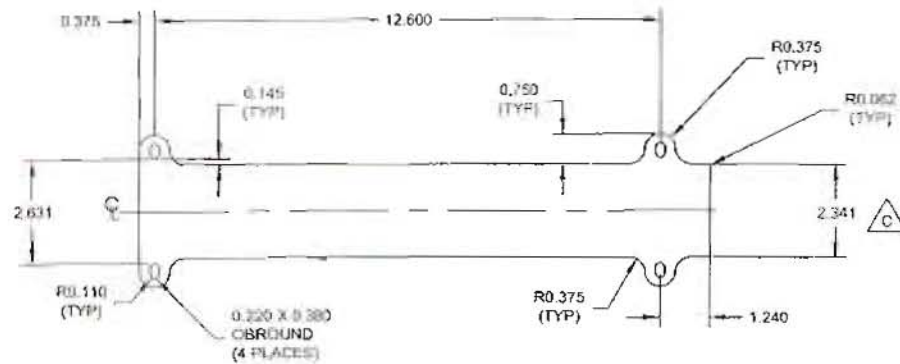
39 84

116623

(2)



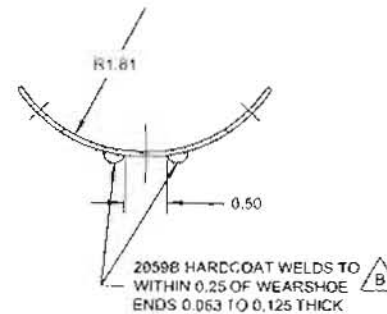




D3512-1F FLAT PATTERN



D3512-1 BENDING DETAIL



SECTION A-A  
SCALE 2:3



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5613 OR AMS 0524, 16 GAUGE (0.053 THICK)  
(REF. DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (A.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.31 lbs

UNCONTROLLED  
SUBJECT TO CHANGE  
WITHOUT NOTICE  
WORK ORDER  
NO. 66831  
11-02-01

RELEASED  
07-11-16

C	ENLARGE OBRUND FOR EASIER ASSEMBLY UPDATE DRAWING FORMAT ADD WEIGHT	PH	07.10.05
B	CHANGE MATERIAL TO STAINLESS STEEL	PH	05.10.97
A	NEW ISSUE	PH	06.04.91
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		

DART AEROSPACE USA, INC  
PORT HADLOCK, WA

DRAWING NO D3512  
REV C  
SHEET 1 OF 1

TITLE WEARPLATE  
SCALE 1:1

COPYRIGHT © 2007 BY DART AEROSPACE USA, INC